

Work Order ID 160900

Friday, May 05, 2017 9:44:32 AM

160900

Page 1

Item ID: PB67-43001-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: **DAS 21** Stop ***NS2***
 Item Name: Fwd Adjustable Blade Support Assembly
 Start Date: 5/10/2017 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 6/1/2017 Req'd Qty: 7.00 ***7*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: **DAS 21** Date: **MAY 05 2017** Tooling: Date: Run Start ***NR1***
 QC: **9-89** Date: **MAY 05 2017** SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-11	D

100 Weld per dwg A/R Aluminum rod Batch: **136158** 0.00 **DAS 24 9-89**
100 Large Fab **2 JUN 07 2017**

Memo 5.81
 1- Make a 0.090" chamfer in the 1.00" hole before welding
 2- Grind weld flush in area of PB67-43001-249 only
 3- ASSEMBLE AND WELD AS PER DWG

102 0.00 **DAS 32 9-89**
102 Mill Conv **2 8**

Conventional Milling Machine
 Memo 1.63
 DRILL AND TAP FOR 1/2"-20 HELICAL INSERT
 INSTALL HELICAL INSERT

17-06-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
JPM 5 0 WUL									
Root Cause		FAULT CATEGORY							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	Part Incorrect ☐
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐	Part Moved ☐
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐	Drawing ☐
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	Finish ☐
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐	Misread ☐
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐		Manufacturing Process ☐		OTHER :					
Misidentified ☐		Past Due ☐							

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							
105									
QC	Memo	0.14							DAS 9 9-89
Quality Control									
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							9 9-89
Quality Control									
160	Green Sandtex (Ref:4.3,5.8) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	1.37							2 17-06-14. DAS 34 9-89
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								
	START TIME: 1:55								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 2:25								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																								OTHER :																																							

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 5/10/2017 **Start Qty:** 7.00 ***7***

Required Date: 6/1/2017 **Req'd Qty:** 7.00 ***7***

Reference: SCHEDULED/U

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
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Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>WAS</u>	0.00				<u>2</u>			<u>gpc</u>
200									
Packaging	Memo	0.07							
Packaging									<u>17.6.20</u>
210	QC21- Final Inspection - Work Order Release	0.00							
210									<u>17/6/21</u> <u>JA</u>
QC	Memo	0.70							
Quality Control									

JUN 20 2017

Picklist Print

Friday, May 05, 2017 9:44:31 AM

Page 1

3

Work Order ID: 160900

160900

Parent Item: PB67-43001-11

PR67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 5/10/2017

Required Date: 6/1/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780		Purchased	No			180	Each	12.0000	1	7			DAS 32 9-89
MS124780									**			17-06-12	
HELICAL INSERT													

Location Loc Qty Loc Code

ST316 12

111064 12

m128173

2

(Not Pulled)

MS27039-1-10

Purchased

No

180

Each

287.0000

8

56

**

JUN 19 2017

DAS
19
9-89

MS27039-1-10

SCREW

Location Loc Qty Loc Code

GA 15

m129341 15

ST280 272

m137164 272

16

NAS1149D0316J

Purchased

No

180

Each

1,053.000

8

56

**

JUN 19 2017

DAS
19
9-89

NAS1149D0316.J

Washer

Location Loc Qty Loc Code

ST264 1053

M134502 1053

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
240 25 200								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Page 2

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PR67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 5/10/2017

Required Date: 6/1/2017

Start Qty: 7.00

Required Qty: 7.00

NAS1149D0363J

Purchased

No

180

Each

629.0000

NA 86 42 56

NAS1149D0363.1

Washer

**

JUN 19 2017

DAS
19
9-89

JUN 19 2017

Location

Loc Qty

Loc Code

GA

137587

42

m134055

42

ST263

587

m137061

100

m137164

487

12 12

PB67-43001-247

Manufactured

No

100

Each

0.0000

1 7

PR67-43001-247

Inner Tube

PB67-43001-249

Manufactured

No

100

Each

4.0000

1 7

PR67-43001-249

Inner Tube Bushing

**

B160829 → 2 6/5/17 CPC

**

B160831 → 2 JUN 07 2017 DAS 24 9-89

Location

Loc Qty

Loc Code

WA003

4

133726

4

PB67-43001-253

Manufactured

No

100

Each

0.0000

1 7

PR67-43001-253

Gusset

PB67-43001-254

Manufactured

No

100

Each

0.0000

1 7

PR67-43001-254

Gusset

PB67-43001-67

Manufactured

No

180

Each

0.0000

1 7

PR67-43001-67

90° Blade Support Assembly

**

B160941 → 2 JUN 07 2017 DAS 24 9-89

Friday, May 05, 2017 9:44:32 AM

Shop Packet Print

Page 2

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**WORK ORDER NON-CONFORMANCE / UPDATE**

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Picklist Print

Page 3

Friday, May 05, 2017 9:44:32 AM

Work Order ID: 160900

160900

Parent Item: PB67-43001-11

PR67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 5/10/2017

Required Date: 6/1/2017

Start Qty: 7.00

Required Qty: 7.00

PB67-43001-69

Manufactured No

180

Each

1.0000

1

7

PR67-43001-69

90 Degree Cover Plate

**

JUN 15 2017

DAS
19
9-00

Location

Loc Qty

Loc Code

Mezz2

1

138691

1

PB67-43001-83

Manufactured No

180

Each

6.0000

1

7

PR67-43001-83

D-Pad Assembly, Short

**

JUN 19 2017

DAS
19
9-00

Location

Loc Qty

Loc Code

Mezz2

6

138687

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

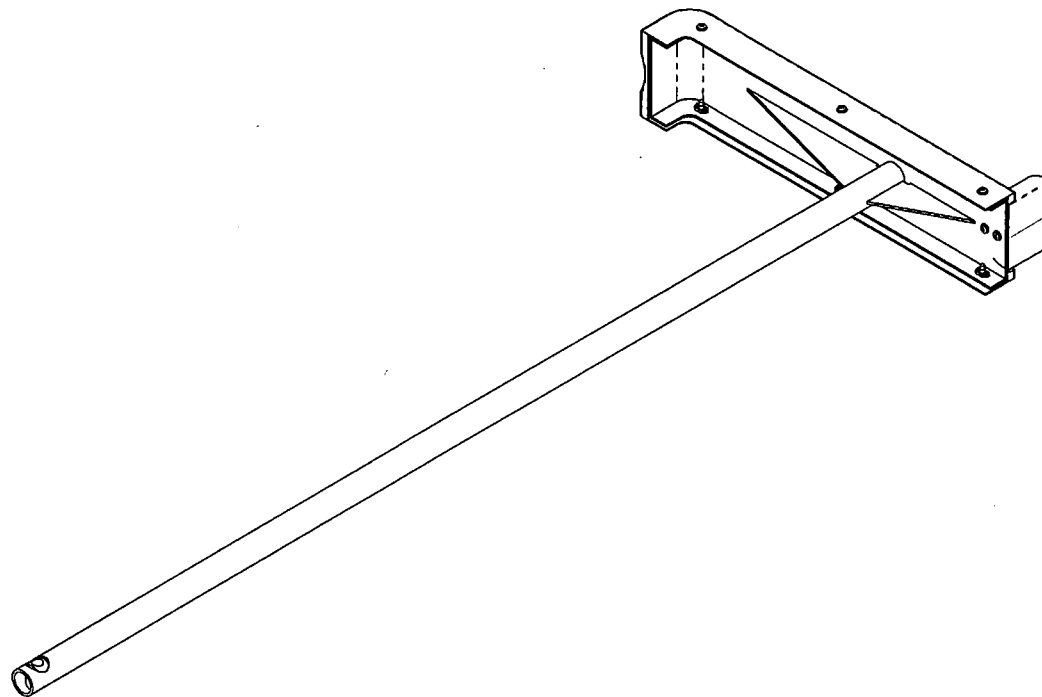
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY

RELEASED
2016-11-09
EWN 16655

ITEM	QTY -11	P/N	DESCRIPTION
1	X	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160900 MJS
1205-05

D	MERGE B67-43001-11W WITH B67-43001-11 REASON, UPDATE WEIGHT B67-43001-11, PARTS-437	SAD	16.11.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR/08-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-11	SHEET 1 OF 3
APPROVED	WM/01	TITLE	FWD ADJUSTABLE BLADE SUPPORT ASSY
DE APPR.	N/A	SCALE	NTS
DATE	16.11.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

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8 7 6 5 4 3 2 1

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B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-69 90-DEGREE
COVER PLATE
REF

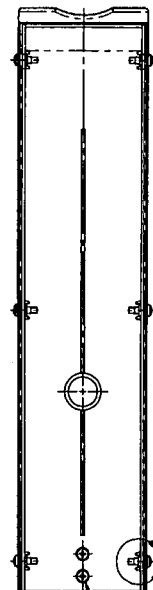
SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT

B67-43001-83
D-PAD ASSEMBLY, SHORT

B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY



MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

C5-2

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.82 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-11W AND B67-43001-83 TO B67-43001-69

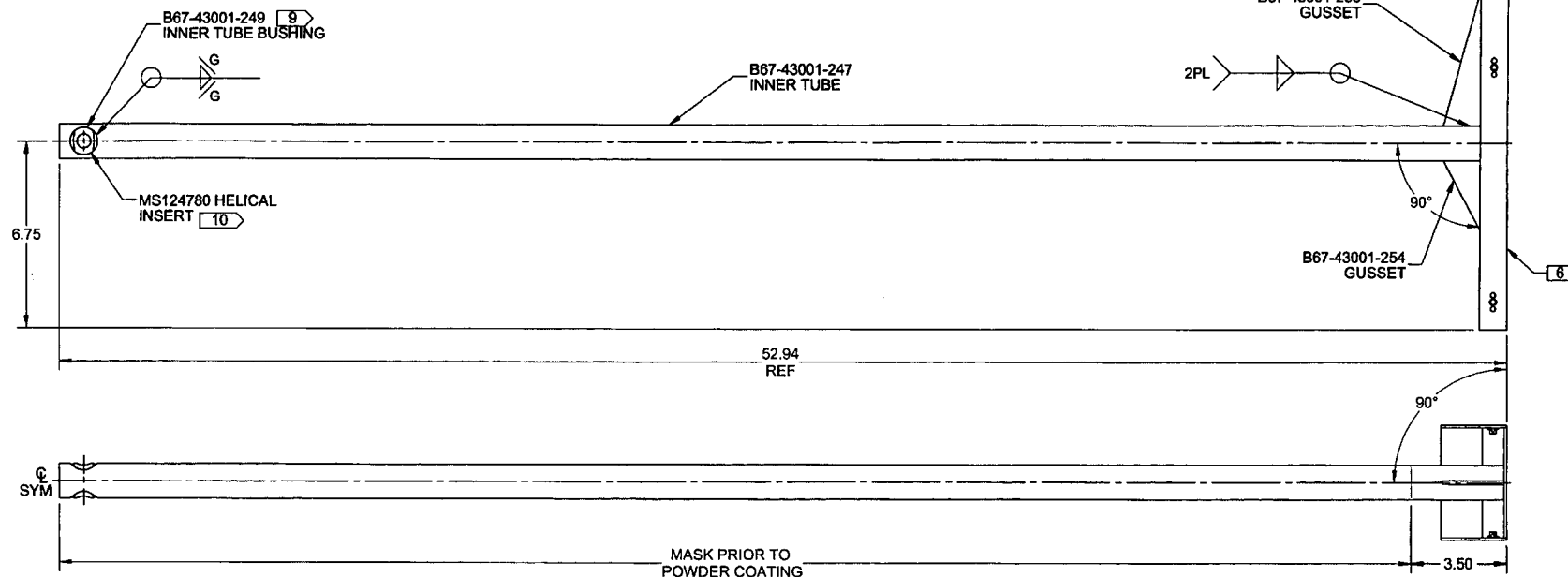
RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-11	SHEET 2 OF 3
APPROVED	WM <i>WA</i>	TITLE	FWD ADJUSTABLE BLADE
DE APPR.	N/A	SUPPORT ASSY	SCALE
DATE	16.11.14		NTS
COPYRIGHT © 1995 BY DART AEROSPACE LTD			
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-247	INNER TUBE
4	1	B67-43001-249	INNER TUBE BUSHING
5	1	B67-43001-253	GUSSET
6	1	B67-43001-254	GUSSET
7	1	MS124780	HELICAL INSERT



B67-43001-11W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-11W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.60 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-11	SHEET 3 OF 3
APPROVED	WM	TITLE	FWD ADJUSTABLE BLADE
DE APPR.	N/A	SUPPORT ASSY	
DATE	16.11.14	SCALE	NTS
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